

Work Order ID 79556

**\*79556\***

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January-27-12 12:51:26 PM

Item ID: D3286-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Doubler  
Start Date: 27/01/2012 Start Qty: 80.00 **\*80\*** Cust Item ID:  
Required Date: 10/02/2012 Req'd Qty: 80.00 **\*80\*** Customer:  
Reference:

Approvals: Process Plan: M.C.J Date: 12/01/27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3286	Rev A

100 0.00

**\*100\***

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3286

Dwg Rev: AProg Rev: A

2-Deburr if necessary

304 . 128

110

**\*110\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120

**\*120\***

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

m 12 . 03 . 06 (80)

m 12 . 03 . 06 (80)

counts  
(XSC)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3286-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Item Name: Doubler  
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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo Form as per Dwg D3286	0.00  0.00		SB 12/03/07		(80)			
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		512/03/07		counts (X80)			
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>LC</u>  Memo ***STOCK IN SKIDTUBE CELL***	0.00  0.00				12/3/7 SP (80)			

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**\*79556\***

January-27-12 12:51:26 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**\*80\***

**\*80\***

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

**Insp.  
Stamp**

0.00

0.00

## Quality Control

12034

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 79556

\*79556\*

Parent Item: D3286-1

\*D3286-1\*

Parent Item Name: Doubler

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP A04.07.14New issueKJ/JLM  
IPP Rev:B Now on Waterjet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	38.5000	0.0749	6.307368			
*M304S11GA*									**				
304/316 0.125 Sheet													

Location

Loc Qty

Loc Code

MAT020

38.5

119048

6.5

120243

32

120604

w/ 12 03 06

W/O:		WORK ORDER CHANGES					
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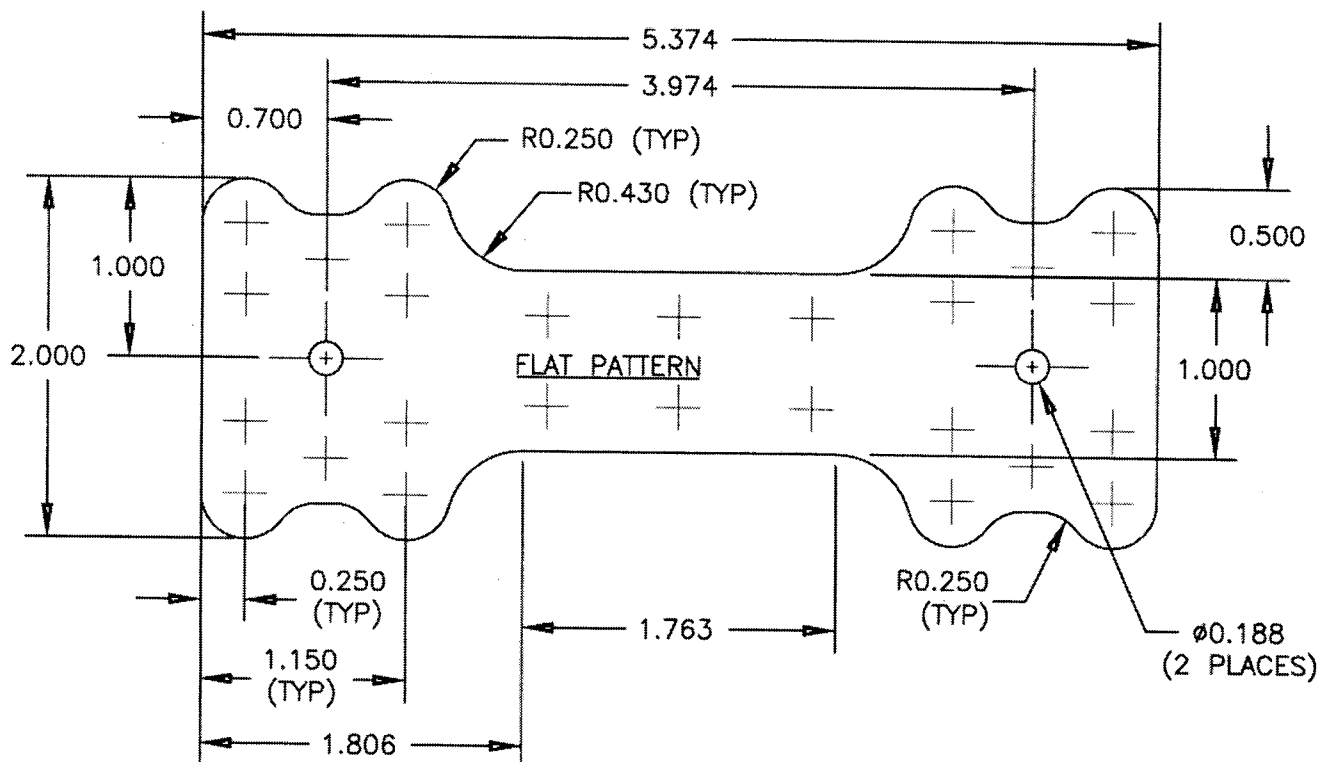
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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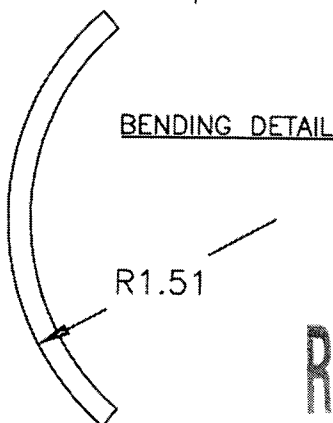
**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.



RELEASED  
04.06.22

SHOP COPY  
REF. TO  
ENCLOSING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 79556465  
12/01/27

#### D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK  
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

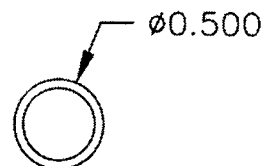
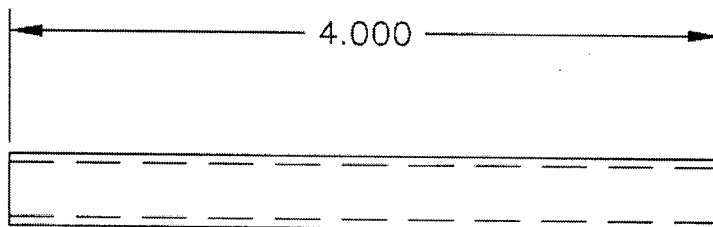
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



**D3286-3 SPACER**

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL  
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED  
04.06.22 *H*

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